

Date: Friday, 13/06/2008 10:47:41 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP SPACER		
Job Number	: 39861B			Part Number	: D30653		
Estimate Number	: 10378			Drawing Number	: D3065 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/06/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 30/06/2008 Qty: 100 Um: Each		
Previous Run	: 38650B						
Written By	:						
Checked & Approved By	: <u>JUL 08.6.13</u>						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		<i>farmed @ GFI</i>
		Comment: Qty.: 0.2287 sf(s)/Unit Total : 22.8690 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: _____
2.0	WATER JET	FLOW WATER JET
		<i>Issue R10: 6563 GFI (100)</i>
		Comment: FLOW WATER JET 1-Cut as per Dwg D <i>Cut + farmed as per dwg D3065 REV B</i> Dwg Rev: _____ Prog Rev: _____
		<i>Co 08/10/11/3 (100)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>received + inspect for transit damage ensure C/C attached</i>
		<i>10/1/4 (100)</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC5	SECOND CHECK
		 <i>S 08/07/07 (100) counted</i>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>1/4 S 08/10/07</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 10:47:41 AM
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Drawing Name: STEP SPACER

Job Number: 39861B

Part Number: D30653

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

W/A Done at GFI Sowls 102

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/A Done 102

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



100

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BK 08-07-08

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SP
xoox

Comment: INSPECT CHEMICAL CONVERSION COAT

8/7/8

10.0 PACKAGING 1

PACKAGING RESOURCE #1



56

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *Sylvie*

8/7/8

100%

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/10 *H*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

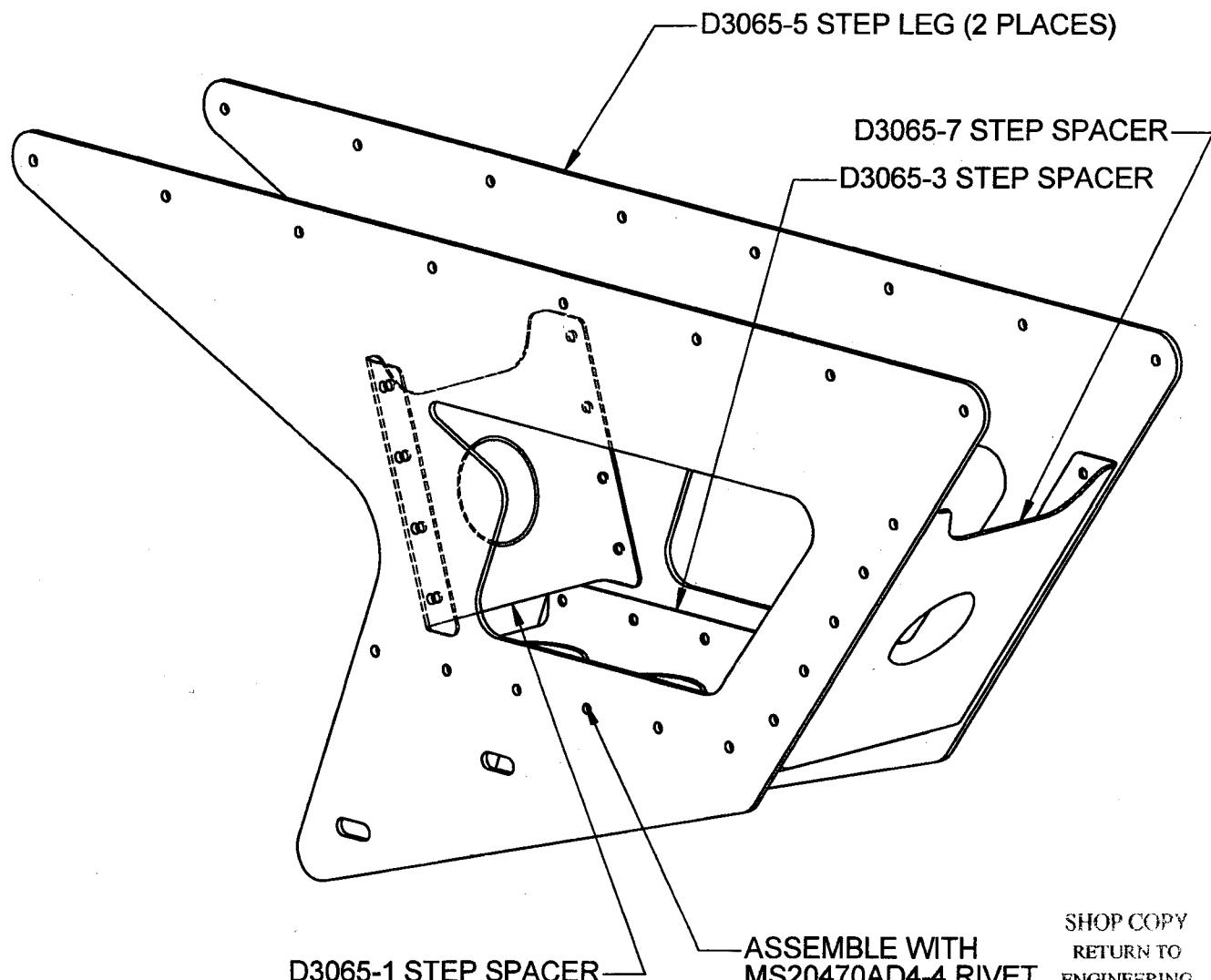
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065
DATE 06.05.23		REV. B SHEET 1 OF 5
		TITLE STEP LEG ASSEMBLY
A	02.09.11	SCALE 1:2
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

RELEASED*06.06.20 [Signature]***D3065-041 STEP LEG ASSEMBLY**

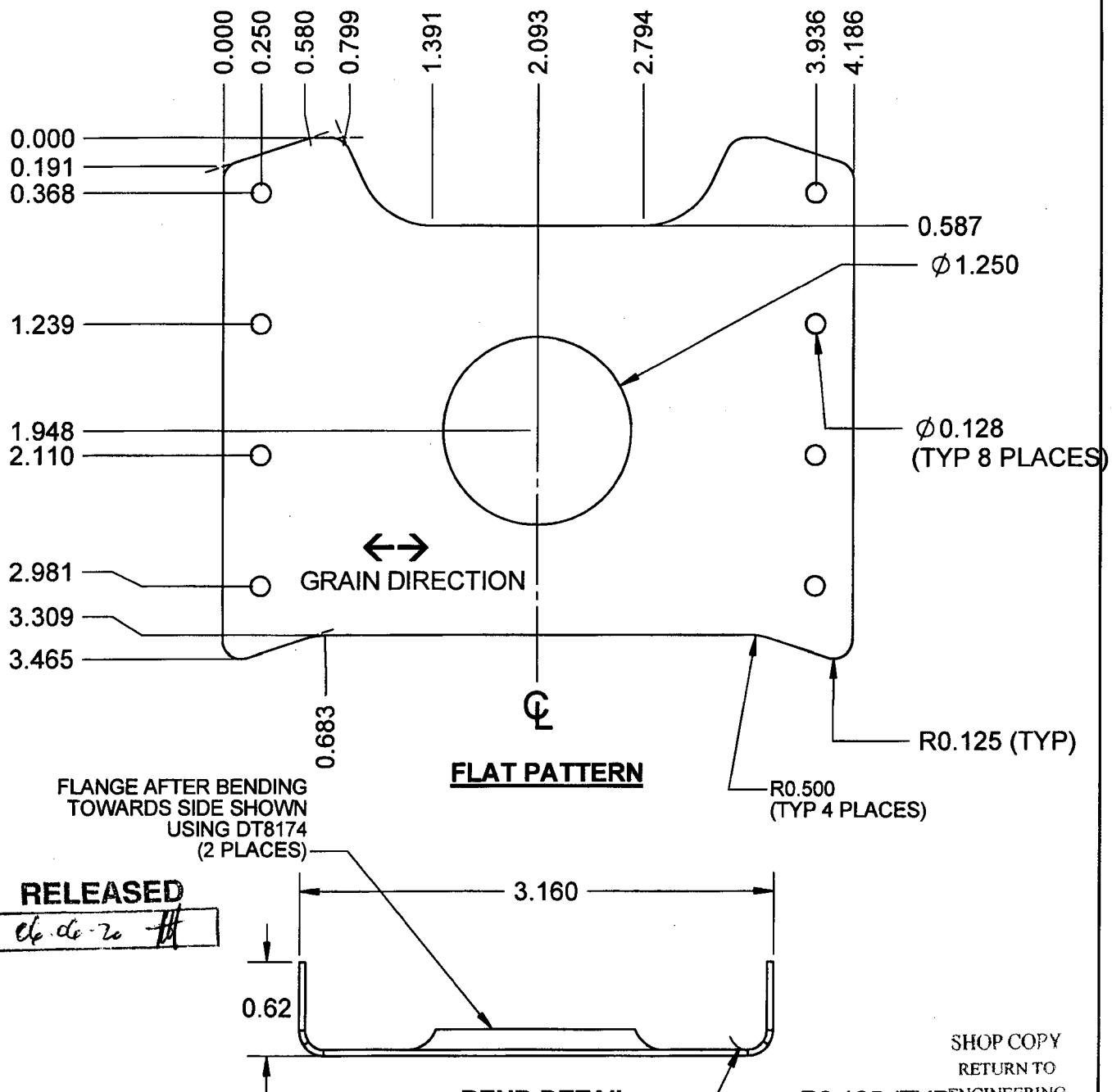
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CHECKED <i>PH</i>	APPROVED <i>M</i>	DRAWING NO. D3065	REV. B	SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1		



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M20)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

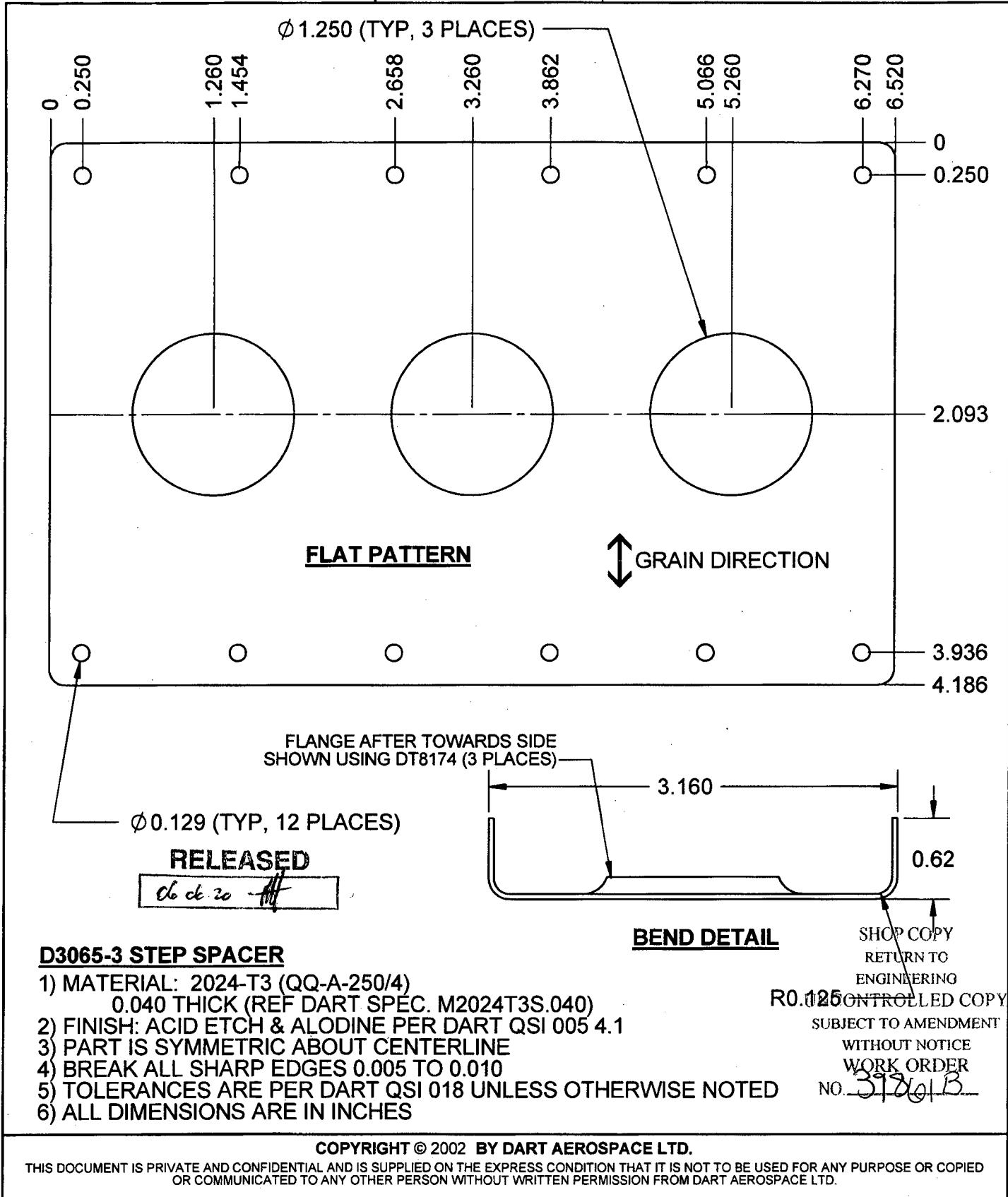
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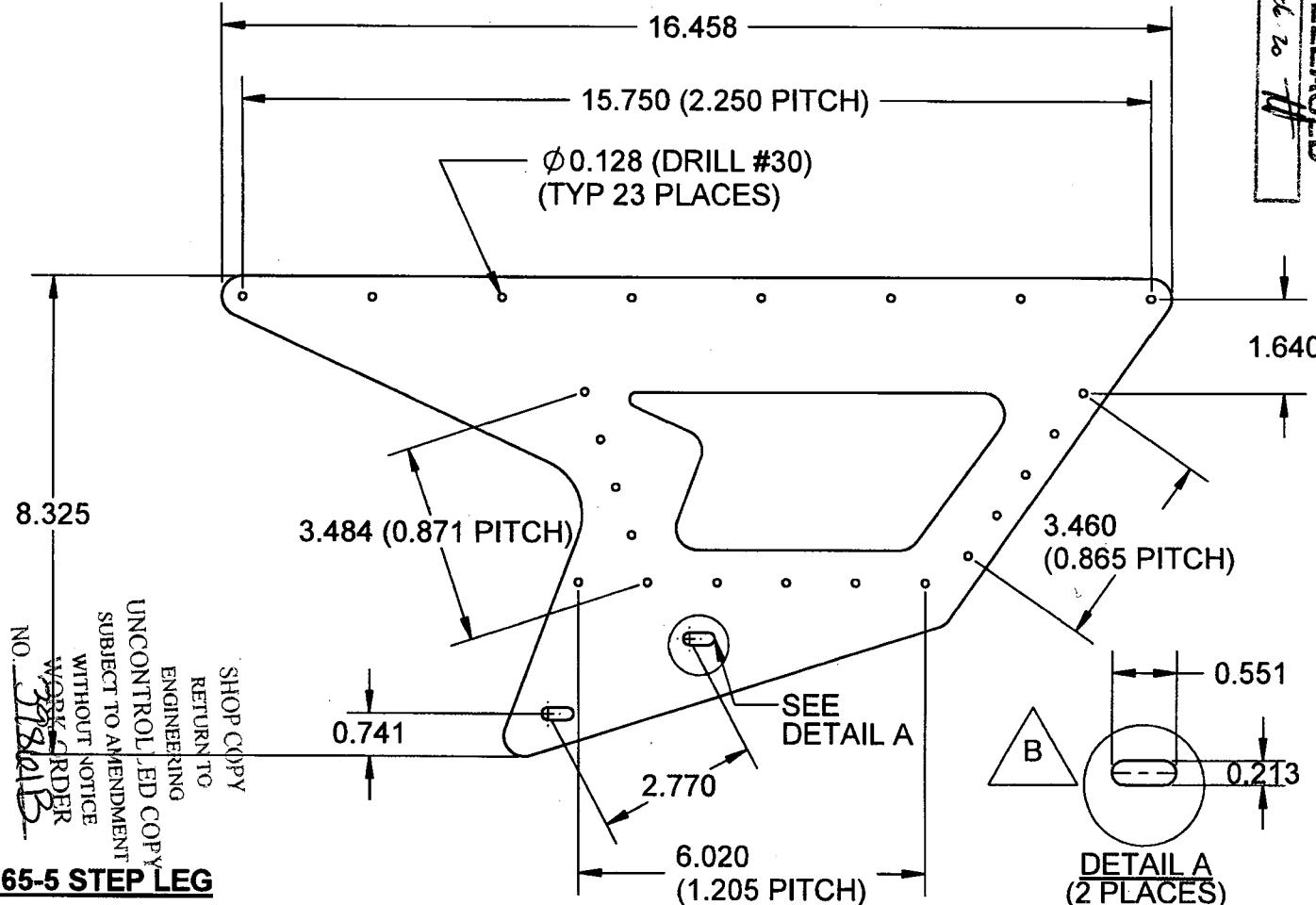
DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1		



DART

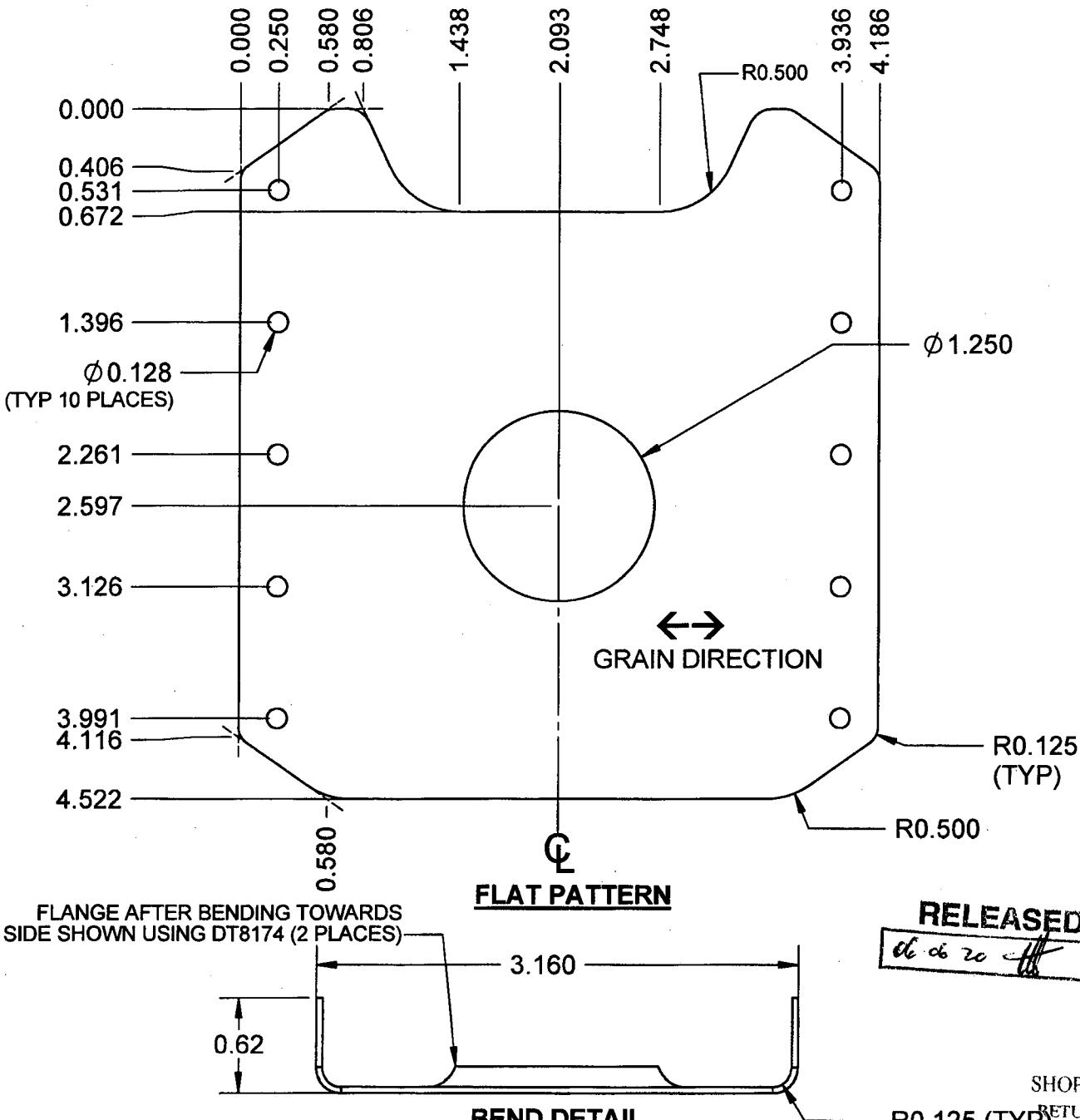
DESIGN <i>11</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>P.H.</i>	APPROVED <i>M.K.</i>	DRAWING NO. D3065
DATE 06.05.23		TITLE STEP LEG ASSEMBLY

RELEASED
06.06.20**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

NO. 3980/B

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180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/07/02	0397185

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0185127	PO00006563	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
100	D30653	STEP SPACER	<i>086707</i>

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECUP PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	4	OUR JOB NO	J0185127	SHIPPING MEMO	0397185	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	100 PCS	PO00006563	D30653	B	STEP SPACER	B
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
AL 2024-T3 (QQ-A-250/4)		SAMUEL / KAISER ALUMINUM			411944A2	
1	PROCESS			PROCESSOR	RELEASE NOTE #	
1	FIRST ARTICLE INSPECTION REPORT ON FILE			GFI	<i>OK/NP</i> CONFORMS	
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 02 JULY 2008

G.F.I. Q.C. REP.

B. Samuels





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTER DE CONFORMITÉ –LETTER OF COMPLIANCE

Date: 18 JUIN 2008

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 73751
Customer's order #:

de commande SSMQ: 881160
SSMO's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Bien à vous,
Yours truly,



Commis à l'administration. Administration Clerk

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393

LET DE COM 12/01/04

SHIP TO:

SAMUEL MISSISSAUGA
2360 DIXIE ROAD
MISSISSAUGA, ON, CA L4Y1Z7

SOLD TO:

SAMUEL LAVAL
2225 FRANCIS HUGHES
LAVAL, PQ, CA H7S1N5

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4112280

BL 101120

CUSTOMER PO NUMBER:	WORK PACKAGE:	CUSTOMER PART NUMBER:		SHIP RUN/LOAD ID:	GOVT CONTRACT NUMBER:
N20349				101120/8	
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:
1058202	2	1-NOV-2007	2024	BARE	T3
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:	GAUGE:	WIDTH:	LENGTH:
4442 LB	1 PCS EST.	2015028	0.0400 IN	48.000 IN	0.000 IN

Certified Specifications

AMS 4037/RevN
CMMR 019/RevD

AMS-QQ-A-250/4/RevA
CMMR 025/RevR

ASTM B 209/Rev06

Test Code: 1504

Test Results

Lot: 411944A2 Cast 398

Drop 18

Ingot 2

S
08/07/07

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	68.1 : 68.1 (470 : 470)	46.8 : 47.0 (323 : 324)	17.9 : 18.3

(ASTM E1251)

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	TOT	0.04
Actual	0.10	0.29	4.5	0.60	1.4	0.02	0.12	0.02	0.01	0.00	0.00	0.04	

ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.60	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poyner